Work Orde Wednesday, June												Page 1
Item ID: Revision ID:	D3574-6			Accept					Setup	Start		
Item Name:	Cabin Floor Pr	otector								Stop		
Start Date: Required Date: Reference:	6/2/2010 6/9/2010	Start Qty: 3.00 Req'd Qty: 3.00			Cust Item I Customer:	D:					1 (881)	
Approvals:	Process Plan	n: <i>M</i>	Date: 16-6-02	Tooling:	Da	nte:	_	I	Run	Start		
	QC:	//	Date:			ite:				Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										<del>-</del>
D3574	Rev	В										
100 Waterjet		FLOW WATER JET  Memo		0.00				ß	10-0	57		
FLOW CNC Waterje	t		r Dwg D3574 □Dwg Rev ecessary	:□Prog Rev:_	₿ □2-							3
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00								
QC Quality Control		Мето	·	0.00	,	^ л		HZ.	10-	6		
120 QC Quality Control		QC8- Inspect parts - sec	ond check	0.00 كى لى	oblor			(F)	>			

W/O:			W	ORK ORDER CHANG	GES							
DATE	STEP	PRO	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:							
	Resolution: Disposition:			on:	QA:	N/C Clo	sed:		Date: _			
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE	(NCR)						
DATE	STEP	Description of NC	Corrective Action Sec Action Description	ction B	Sign &	Verifica		Approval	Approvai			
		Section A	Initial Chief Eng	Chief Eng		Date	Section	1 C	Chief Eng	QC Inspector		
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### Work Order ID 59363

Wednesday, June 02, 2010 1:17:26 PM



Page 2

Item ID:

D3574-6

Accept

Tool # Plan

Code

Setup Start



**Revision ID:** 

Item Name:

Cabin Floor Protector

**Start Date:** 

6/2/2010

Start Qty: 3.00

Required Date: 6/9/2010

Req'd Qty: 3.00



Cust Item ID:

**Customer:** 

Tool ID

Reference:

**Approvals:** 

QC:

Process Plan:

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Stop

Reject

Number

Reject

Qty



Insp.

Stamp

Sequence ID/ **Work Center ID** 

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr if necessary.

Set Up/ **Run Hours** 

0.00

0.00

Qty

Accept

140

QC5- Inspect part completeness to step on W/O

Quality Control

150

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	IANGE	E	Зу	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQA:	Date:			
						QA: N/C Closed: Date:					
NCR:		·	WORK OR	DER NON-CONFOR	MANCE (	NCR)			***************************************		
DATE	STEP	Description of NC	In idial		Section B	···· 0	Verification	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section C	Chief Eng	QC Inspector		
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#### Work Order ID 59363

Wednesday; June 02, 2010 1:17:26 PM



Page 3

Item ID:

D3574-6

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Cabin Floor Protector

**Start Date:** 

Required Date: 6/9/2010

6/2/2010

Start Qty: 3.00

Operation

Description

Req'd Qty: 3.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

Run Hours

Date:

Date:

Run Start

Stop

Sequence ID/

Work Center ID

160

Memo

QC21- Final Inspection - Work Order Release

Set Up/

**Tool ID** 

Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

10/06/09/2 pl/10-4-08 (3)

Dart	Aer	ospa	ce Ltd
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W/O:			NGES	ES						
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	• •	PAR #:	Fault Cat	egory:	NCR:	Yes N	o DQA:		Date:	
Resolution: Disposition:										
NCR:		\	WORK ORE	DER NON-CONFOR	MANCE (	NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Description	Section B	Sign &	Verificat Section		Approval Chief Eng	Approval QC Inspector
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#### **Picklist Print**

Wednesday, June 02, 2010 1:46:01 PM

Work Order ID: 59363

Parent Item:

D3574-6

Parent Item Name:

Cabin Floor Protector

Comments:

IPP Rev : A New Issue 07.07.23

EC verified by:JLM



Start Date: 6/2/2010

Required Date: 6/9/2010

Page 1

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,769.706	33.6	100.8504			

GE PLASTICS LEXAN SHEET

			1810-	6-7
Location	Loc Oty	Loc Code		
MAT	1769.7068			$\overline{(}$
111710	64			(5)
112585	173.383			
114032	1532.3238		114037	

Dart Aerospace L
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W/O: WORK ORDER CHAN					GES					
DATE	STEP	PRO	CEDURE CHA	NGE	В	Date Qty		Approval Chief Eng / Prod Mgr	.Approval QC Inspector	
Part No		PAR #:								
Resolution: Disposition			n:	QA: N/	C Clo	sed:		Date:		
NCR:		V	VORK ORD	ER NON-CONFORM	MANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng		gn & Date	Verifica Section		<b>Approval</b> Chief Eng	Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	59363
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing	Tolerance	Actual	Assent	Bainet	Method of	0
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	4			
7.37	+/-0.030	7.37	4			
11.00	+/-0.030	11.00	7			
15.25	+/-0.030	15.25	\$			
25.87	+/-0.030	78.26	<b>18</b> 0			· · · · · · · · · · · · · · · · · · ·
39.75	+/-0.030	39.74	*			
44.75	+/-0.030	44.75	*			
58.38	+/-0.030	58.38	X-			•
63.50	+/-0.030	63,50	<i>5</i> 4			
65.25	+/-0.030	65.2€	٢			
10.25	+/-0.030	10.05	*			
11.87	+/-0.030	11.87	7	<u> </u>		
14.75	+/-0.030	14.75	1			• • •
26.00	+/-0.030	26.00	V			
40.87	+/-0.030	40.87	4			
45.00	+/-0.030	1 -	<b>X</b> O			
48.00	+/-0.030	I	×			
55.13	+/-0.030	55.13				
61.25	+/-0.030	61.05	7			
61.88	+/-0.030	61.82	Ź			
64.63	+/-0.030	64.63	8			
1.13	+/-0.030	1.13	Đ_			
7.63	+/-0.030	7.63	X,			
11.00	+/-0.030		友			
22.10	+/-0.030		*			
22.50	+/-0.030		*			
24.50	+/-0.030	24.56	*			
35.13	+/-0.030	35,13	×			
36.50	+/-0.030	36.50	*			
40.00	+/-0.030	1	X			
41.88	+/-0.030	1.4.00	<b>X</b> 50			
43.63	+/-0.030	1	7			
6.75	+/-0.030	6.75	p			
9.50	+/-0.030	<del></del>				
5.00	.7.0.000	1/50	8			·

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W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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	Res	olution:	Disposition	l:	Date: _						
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DART AEROSPACE LTD	Work Order:	39363
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

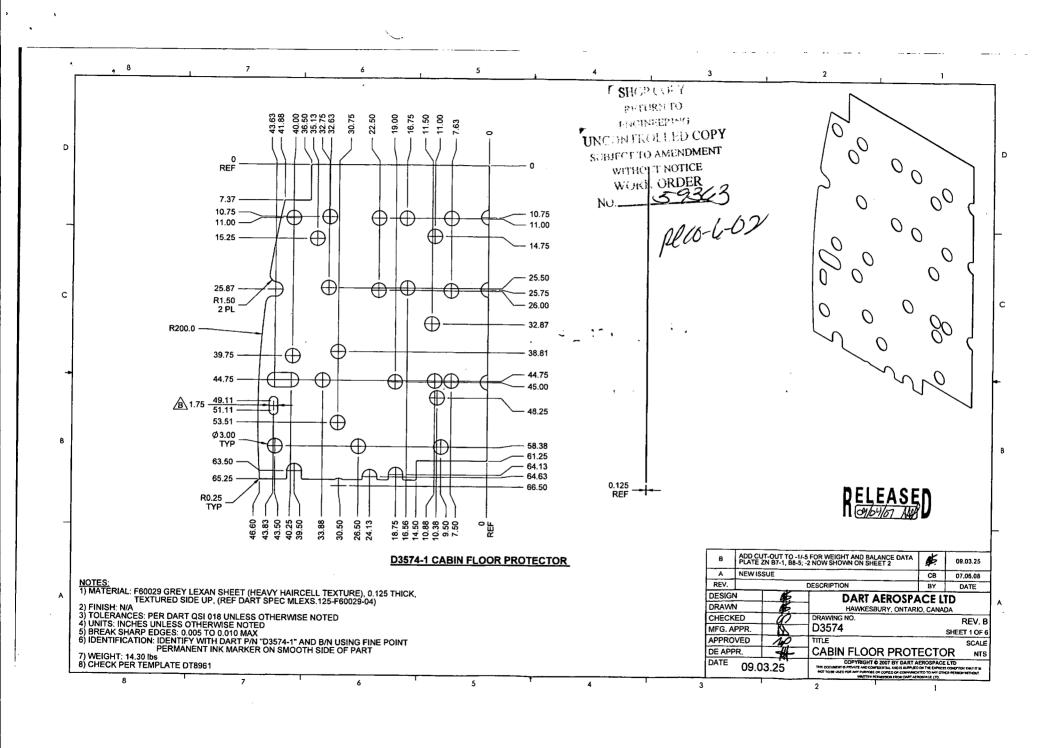
Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	lu.38	4			
14.50	+/-0.030	14.50	1			
16.75	+/-0.030	16.75	<b>&gt;</b>			
18.94	+/-0.030	18 94	7.			
19.00	+/-0.030	19.00	<u>ح</u>			
24.13	+/-0.030	74:13	7			
33.88	+/-0.030	33-88	*			
39.50	+/-0.030	34.50	<b>&gt;</b>			
40.25	+/-0.030	40.98	<b>&gt;</b>			
43.50	+/-0.030	43,50	مرا			
46.60	+/-0.030	46.60	4			
0.125	+/-0.010	1133	مذ			
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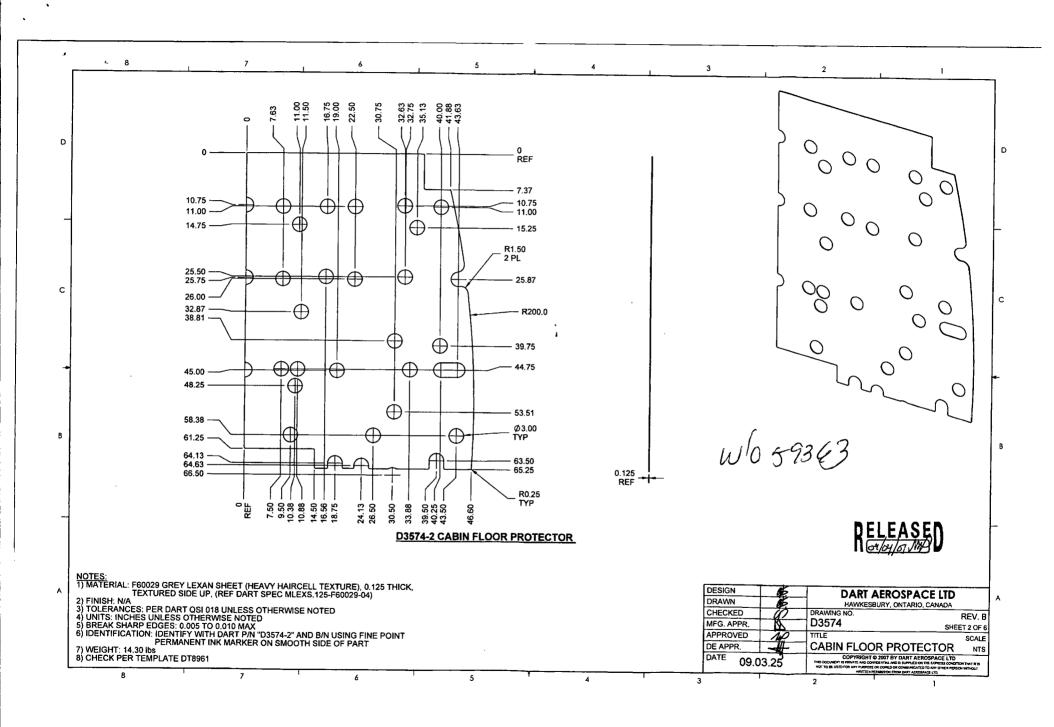
Measured by:	图	Audited by:	Prototype Approval:	N/A
Date:	1067	Date: wolot of	Date:	N/A

Rev	Date	Change .	Revised by	Approved=
Α	08.01.16	New Issue	KJ//DD . A	
В	09.05.15	Dimensions updated per Dwg Rev B	KJ 🙀	1//
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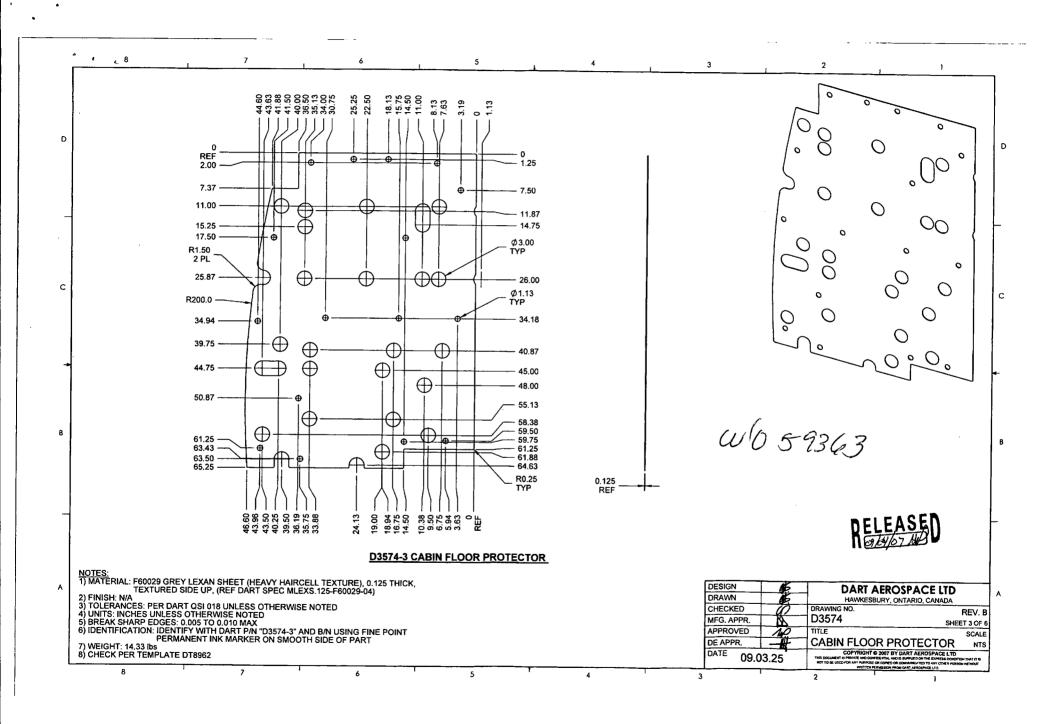
W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				(	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cate	jory:	NCR: Yes No DQA: Date: _							
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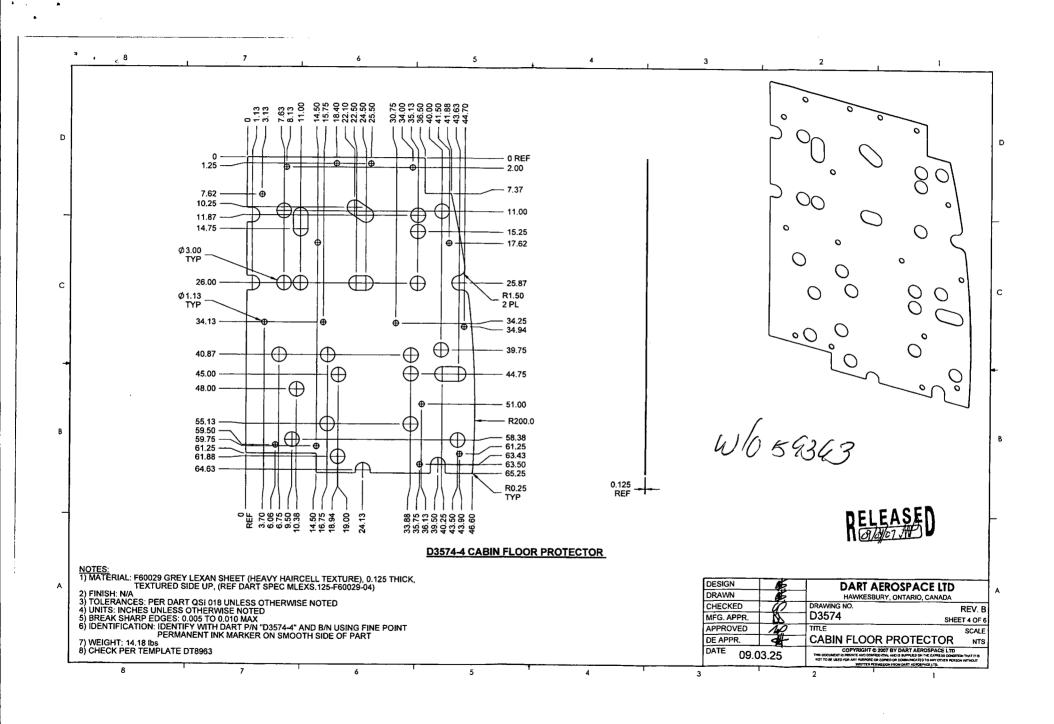
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector	
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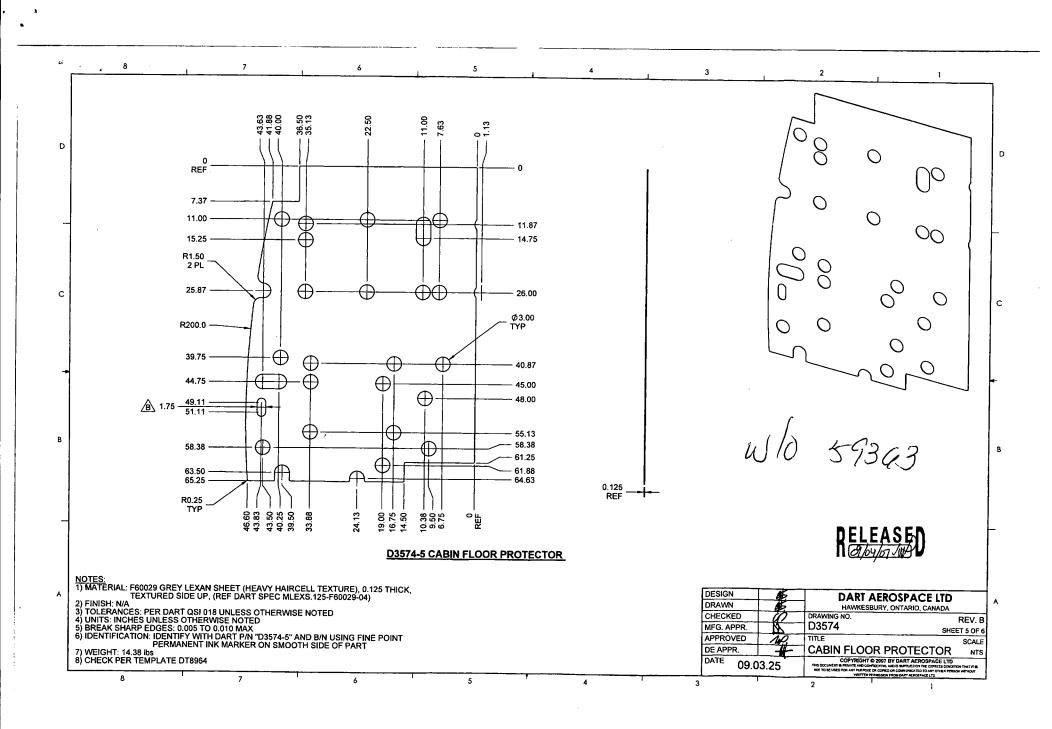
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DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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DATE	STEP	Description of NC		Corrective Action Section B			Verific	cation	Approval	Approvai					
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
			Disposition: Q			A: N/C Closed:			Date:		
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (	NCR)					
DATE	STEP	Description of NC Section A	f., 144	tion B		Verific	ation	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR	: Yes	No <b>DQ</b>	A:	Date:		
					QA: N/C Closed:						
NCR:			WORK ORE	DER NON-CONFORM	ANCE	(NCR	)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Ciana 9	Verific	ation	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector	
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11.00 22.10 22.50 24.50 35.13 36.50 40.00 41.88 43.63 D ŘEF 7.37 10.25 - 11.00 11.87 14.75 15.25  $\oplus$ 26.00 25.87 R1.50 2 PL Ø3.00 TYP  $\oplus$  $\oplus$ 39.75 40.87 45.00 44.75  $\oplus$ 48.00 R200.0 55.13 - $\oplus$ 58.38 61.25 61.88 63.50 64.63 65.25 0.125 R0.25 REF 6.75 9.50 10.38 14.50 16.75 18.94 19.00 39.50 40.25 43.50 46.60 **D3574-6 CABIN FLOOR PROTECTOR** 

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: N/A
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

. 7

8

7) WEIGHT: 14.27 lbs
8) CHECK PER TEMPLATE DT8965

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3574 MFG. APPR. SHEET 6 OF 6 APPROVED TITLE **CABIN FLOOR PROTECTOR** DE APPR. COPYRIGHT © 2007 BY DART A EROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDIT
HOT TO BE USED FOR ANY PURPOSE OR COMBENION THE TO TO ANY OTHER RIGHS. DATE 09.03.25

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W/O:			WC	ORK ORDER CHANG	iES						
DATE	STEP	PRO	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
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NCR:		T		ER NON-CONFORM							
DATE	STEP	Description of NC Section A	\		ion B	Verification	cation Approval				
DAIL			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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